

Date: Wednesday, 2/20/2008 4:18:07 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY (350)	
Job Number	: 37513C		Part Number	: D2221 <i>14080221</i>	
Estimate Number	: 10189		Drawing Number	: D2221 UR, D2235	
P.O. Number	:		Project Number	: N/A	
This Issue	: 2/20/2008		Drawing Revision	: F/B1	
Prsht Rev.	: NC		Material	:	
First Issue	: 1/		Due Date	: 3/15/2008	
Previous Run	: 37512C		Qty:	1	
Written By	:		Um:	Each	
Checked & Approved By	:				
Comment	: Est Rev: 05.09.02 Added D3442-1 KJ/JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	4 D3166-1	RIB	<i>037611</i>
			<i>FC 08 04 01</i>
2.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	2 D2232-3	Hinge bracket	<i>036846</i>
			<i>FC 08 04 01</i>
3.0	D2325	Support Gusset (350 Bask)	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	4 D2325	Support Gusset	<i>036691</i>
			<i>FC 08 04 01</i>
4.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	2 D2327-3	Bushing	<i>036479</i>
			<i>FC 08 04 01</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:18:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 37513C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D2581 Mounting Bracket B37248

FC 08 04 01

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3442-1 Shim D34610

FC 08 04 01

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)

Pick:

Qty Part Number Description Batch  
39.69 sf M304EX0.75-16F Expanded Metal M107S11

FC 08 04 01

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick: .065 per .03-21

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M107S11

FC 08 03 31

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235 FC

2-Drill hole in D2221-3 as per Dwg D2221 FC

3-Deburr FC

4-Remove all markings on material before welding FC

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

FC 08 04 01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:18:08 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 37513C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-08 (1)

11.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 08-04-08 (1)

12.0 POWDER COATING POWDER COATING



M 107550

(1)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL 08-04-08

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ML 08/04/09

14.0 QC21 FINAL INSPECTION/W/O RELEASE



08/04/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



cmf 08-04-09

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS

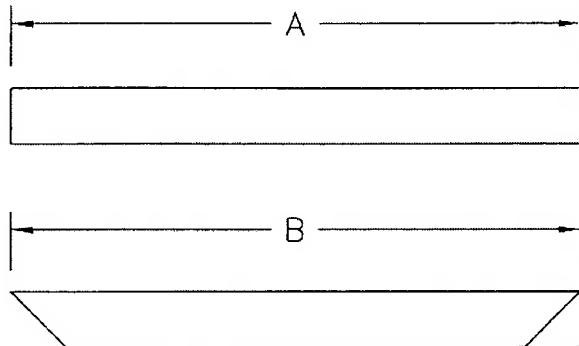
RELEASED

05.08.14 *[initials]*

C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

## PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

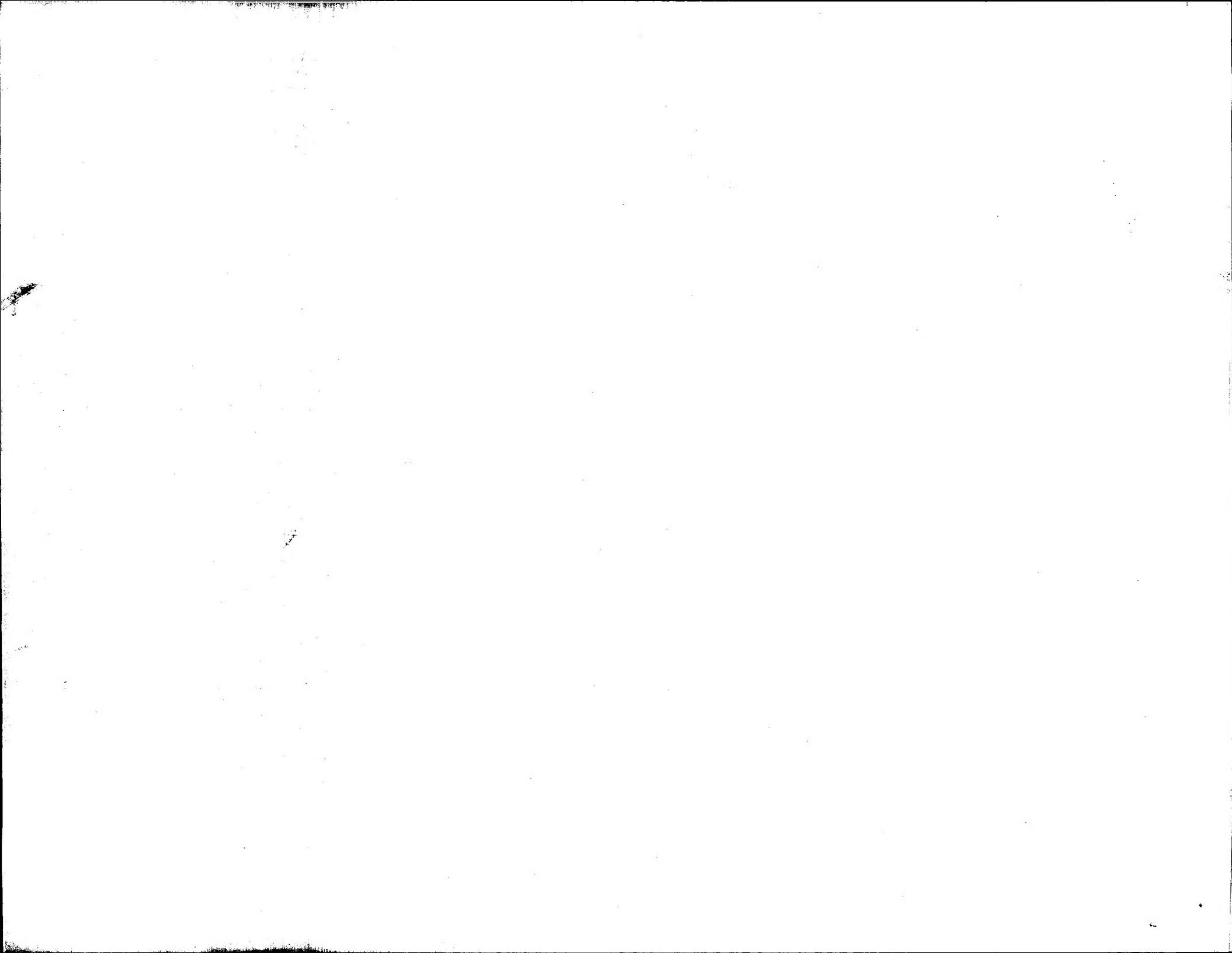
PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING  
(REF. DART SPEC M304TS0.750W.060) *0.065 +/- 0.02 .21*
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

**UNDER REVIEW**  
*08.07.15 #*  
 TUBING TYPE  
 CHANGED COTTONS  
 RETURN TO  
 ENGINEERING  
 45 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
*NO. 375134*





DESIGN BW		DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWN BY PH	REV. F
		DRAWING NO. D2221	SHEET 2 OF 3
DATE 05.06.07	TITLE BASKET BASE ASSEMBLY (350)		SCALE 1:20

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SKIN INSIDE SURFACE OF BASKET WITH MESH. TACK WELD EACH END OF STRAND TO FRAME

1.75 (REF)

92.50

46.25

1.75

D2221-1 (2)

5  $\varnothing$ 0.257 (TYP 5 PLACES)  
(DRILL WHEN ASSEMBLING WITH D2989-041/-043 LID ONLY)

6.50 (TYP BOTH ENDS)

D2221-7

D2221-5 (2)

D2221-3 (2)

25.50

18.88

55.25

18.87

TYP

30.00

34.50

30.00 (REF)

D2581 (2)

D2232-3 (REF)

D3442-1 (REF)

NO 37513C

UNCONTROLLED ENGINEERING DRAWING  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
RETURN TO  
SHOP COPY

19.63

56.00 (REF)

56.00 (REF)

D2221-7 (REF)

D2235-1

19.62

96.00 $\pm$ 0.01

DETAIL D

D2232-3

D3442-1

DETAIL D  
(SCALE 1:1)  
(TYP BOTH ENDS)

08-02-21  
TUBING TO BE  
CHANGED TO 1/2 IN  
WALL  
08-02-21

RELEASER  
05-08-19

UNDER REVIEW  
08-02-21

D2221 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

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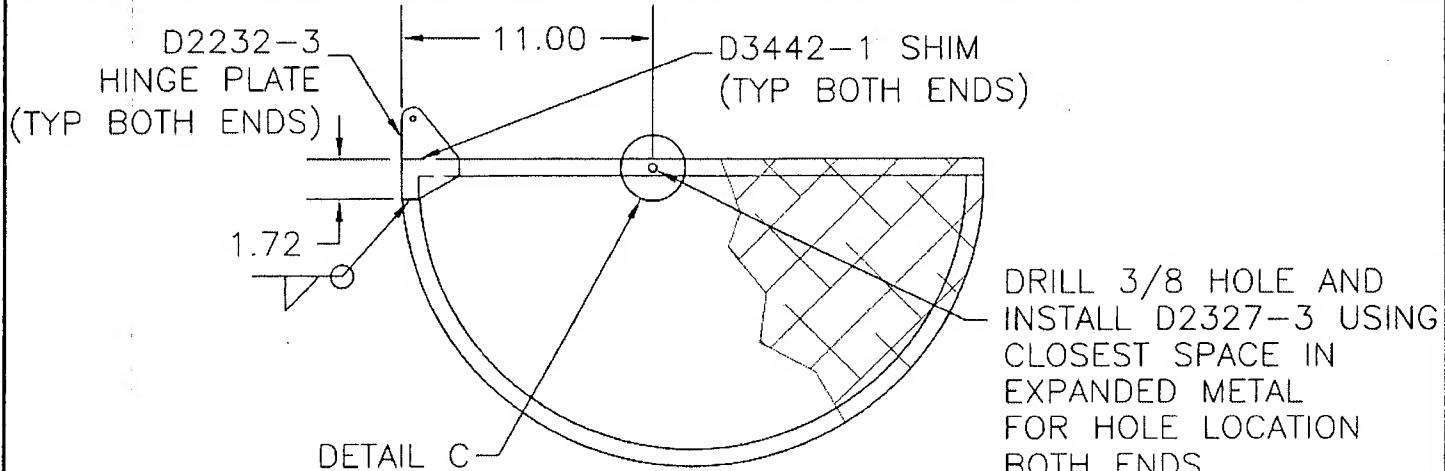
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**D2221 BASKET BASE ASSEMBLY**

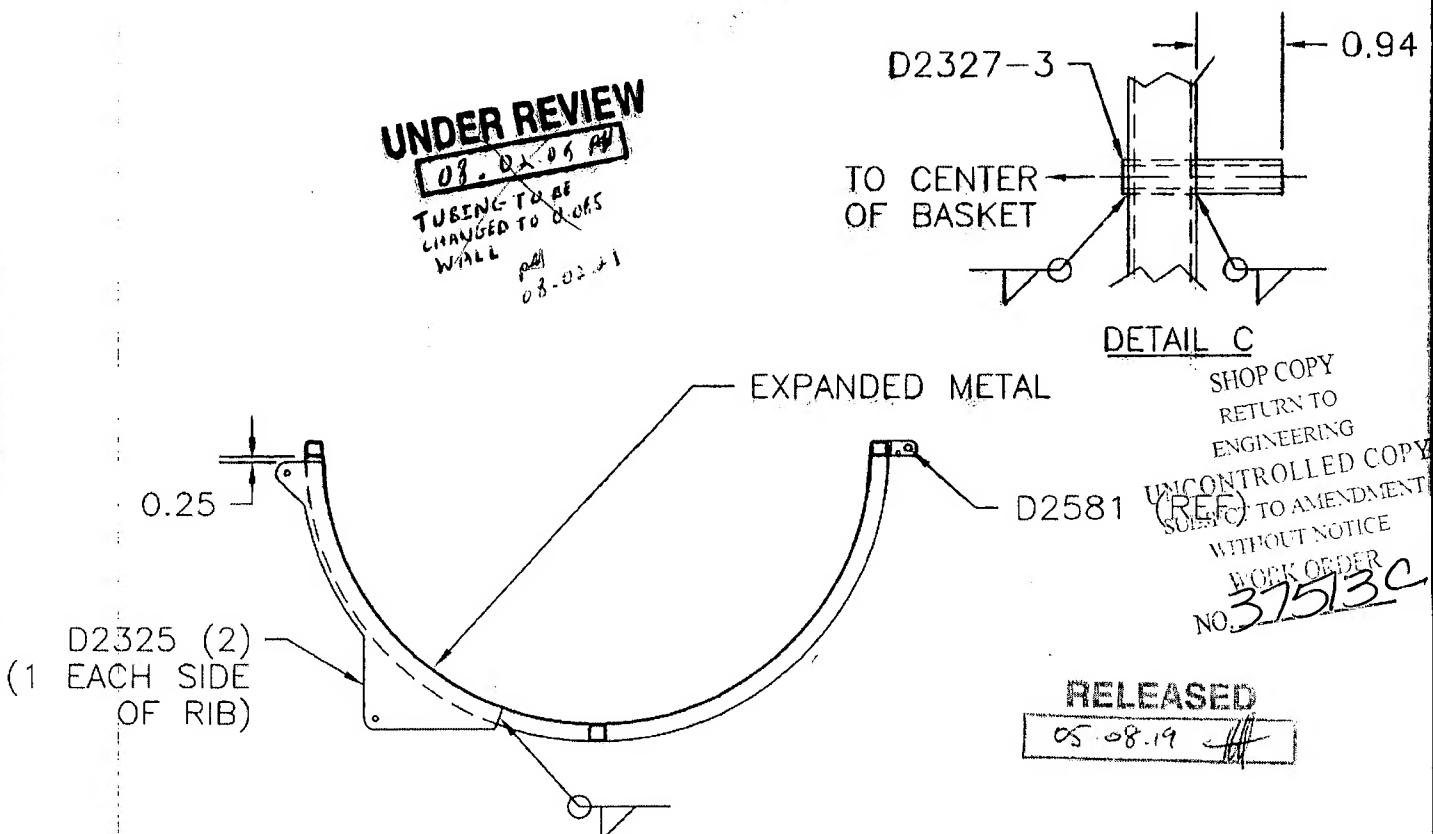
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

**DART**

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



### SECTION A-A SAME BOTH END RIBS

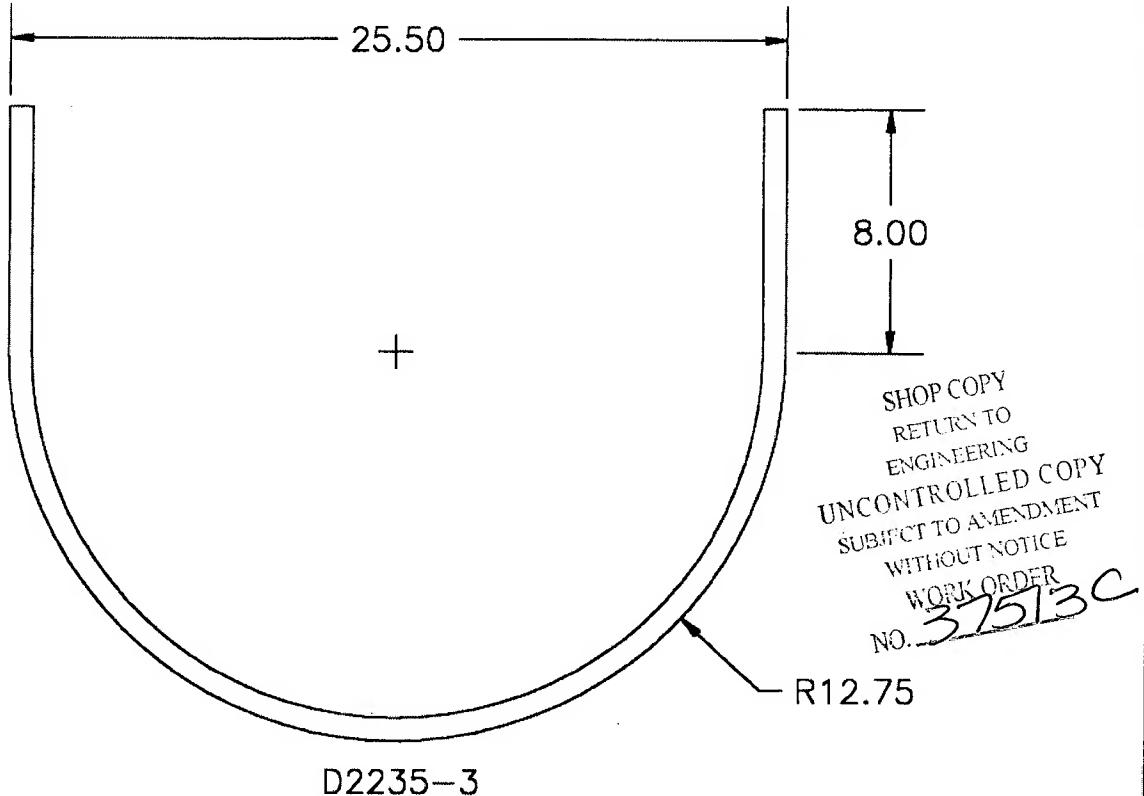
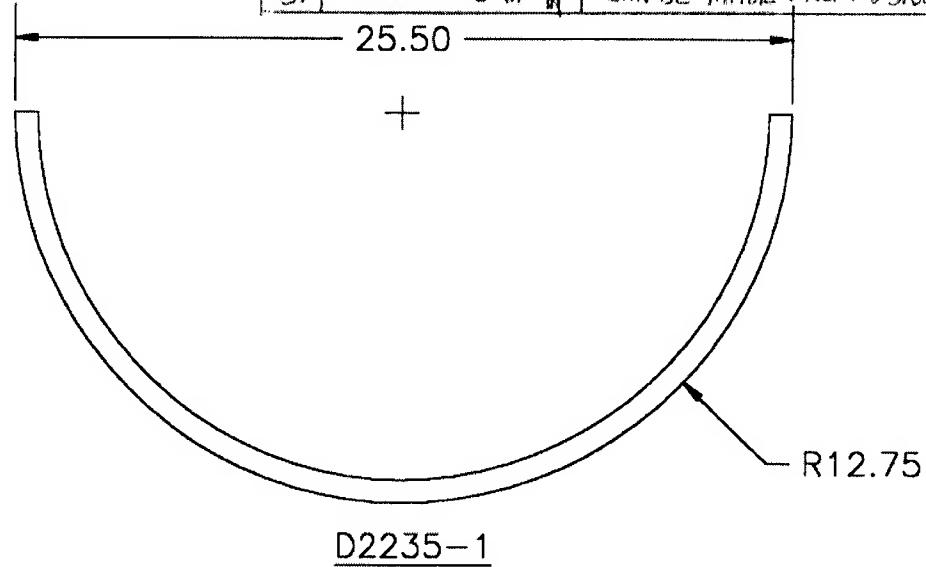


### SECTION B-B SAME BOTH CENTER RIBS

**DART**

DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235
DATE 94:12:16		REV. B SHEET 1 OF 1 SCALE

B1 02.03.06 (1/4) CAN BE MADE FROM D3166-1

**RELEASED**  
R 960507CAN BE MADE FROM D3166-1 B1  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

